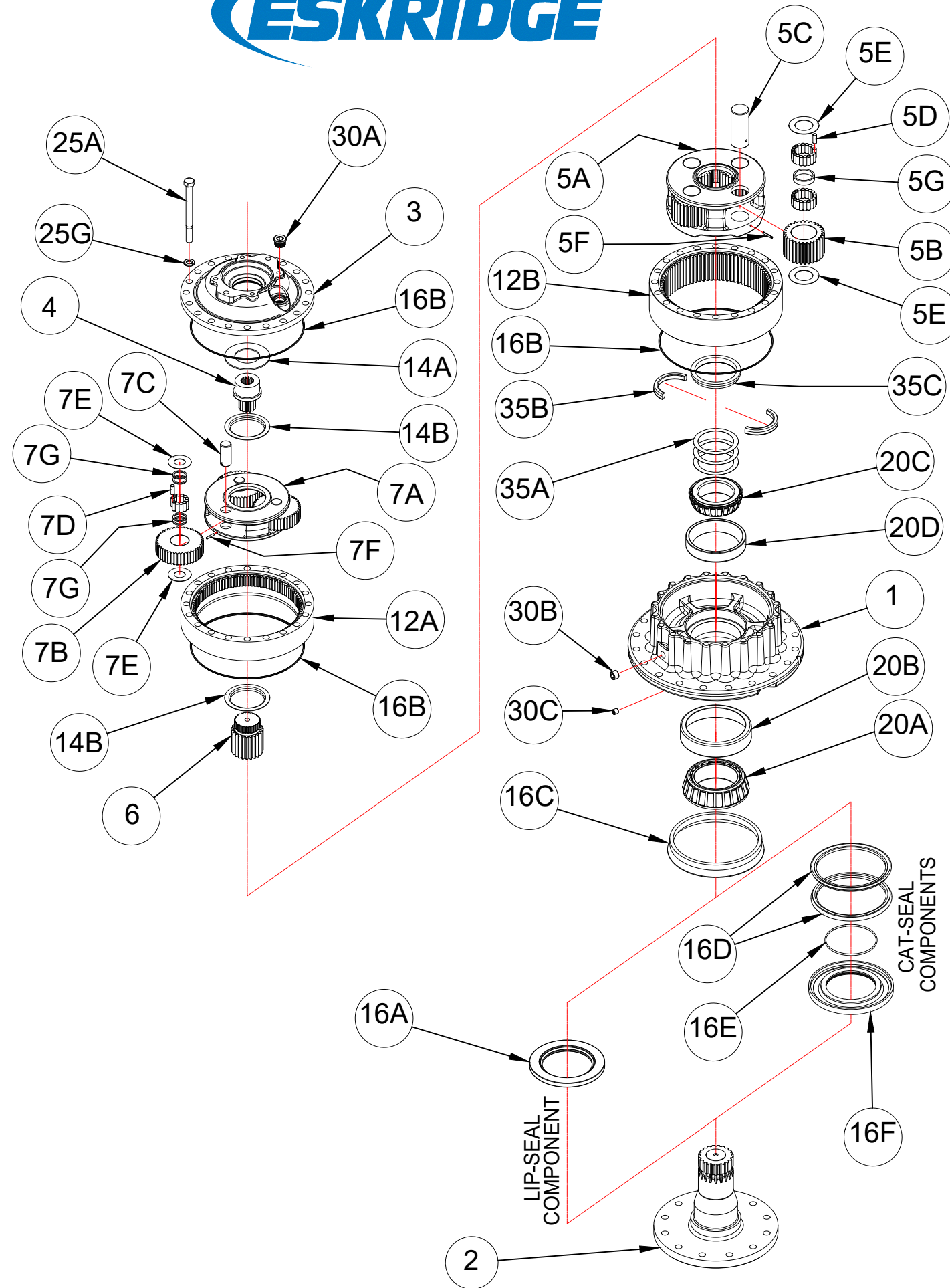




# MODEL 312L SPINDLE OUTPUT

EQUIPPED WITH  
"LOAD-N-LOCK" SHAFT  
RETENTION SYSTEM.

| ITEM        | QTY | DESCRIPTION  | RATIO →                         |                                |                            |                               |
|-------------|-----|--|---------------------------------|--------------------------------|----------------------------|-------------------------------|
|             |     |  | 20.25:1<br>4.3125:1<br>4.6957:1 | 26.34:1<br>5.609:1<br>4.6957:1 | 29.58<br>6.3:1<br>4.6957:1 | 40.24:1<br>8.57:1<br>4.6957:1 |
|             |     | EFFECTIVE:<br>FROM: S/N 110310 03/16/13<br>TO: CURRENT |                                 |                                |                            |                               |
|             |     |  | PART NUMBER                     |                                |                            |                               |
| 1           | 1   | 252A BASE - ROUND (LIP SEAL)                           | 25-004-3206                     |                                |                            |                               |
|             | 1   | 252F BASE - FLANGELESS (LIP SEAL)                      | 25-004-3207                     |                                |                            |                               |
|             | 1   | 252A BASE - ROUND - W/CAT SEAL                         | REQ'D FOR CAT SEAL              | 25-004-3208                    |                            |                               |
|             | 1   | 252F BASE - FLANGELESS W/CAT SEAL                      | REQ'D FOR CAT SEAL              | 25-004-3204                    |                            |                               |
| CUSTOM BASE |     |  | -----                           |                                |                            |                               |
| 2           | 1   | S1 - OUTPUT SHAFT - SPINDLE                            | 25-004-4052L                    |                                |                            |                               |
| 3           | 1   | A - SAE 'A' COVER                                      | 25-005-2061                     |                                |                            |                               |
|             | 1   | B - SAE 'B' COVER                                      | 25-005-2051                     |                                |                            |                               |
|             | 1   | C - SAE 'C' (2 AND 4 BOLT)                             | 25-004-1222                     |                                |                            |                               |
|             | 1   | D - SAE 'D' COVER                                      | 25-004-1232                     |                                |                            |                               |
| 4           | 1   | INPUT GEAR - 14T-12/24 SPLINE                          | 25-004-1732                     | 25-004-1792                    | 25-004-1742                | 25-004-1812                   |
|             | 1   | INPUT GEAR - 13T-8/16 SPLINE                           | 25-004-1762                     | 25-004-1802                    | 25-004-1772                | 25-004-1782                   |
| 5           | 1   | CARRIER ASSY - SECONDARY                               | 25-005-2161                     |                                |                            |                               |
| 5A          | 1   | CARRIER - SECONDARY                                    | 25-004-1602                     |                                |                            |                               |
| 5B          | 4   | PLANET GEAR - SECONDARY                                | 25-004-1632                     |                                |                            |                               |
| 5C          | 4   | PLANET SHAFT - SECONDARY                               | 25-004-1432                     |                                |                            |                               |
| 5D          | 144 | ROLLER - 2 ROWS, 18 EACH ROW                           | 01-106-0010                     |                                |                            |                               |
| 5E          | 8   | THRUST WASHER - SEC. PLANET                            | 25-004-1462                     |                                |                            |                               |
| 5F          | 4   | ROLL PIN (3/16 X 1 1/4)                                | 01-153-0190                     |                                |                            |                               |
| 5G          | 4   | SPACER - SEC PLANET BEARING                            | 25-004-1452                     |                                |                            |                               |
| 6           | 1   | SUN GEAR - SECONDARY                                   | 25-004-1622                     |                                |                            |                               |
| 7           | 1   | CARRIER ASSY - PRIMARY                                 | 25-005-2201                     | 25-005-2181                    | 25-005-2211                | 25-005-2171                   |
| 7A          | 1   | CARRIER - PRIMARY                                      | 25-004-1692                     | 25-004-1642                    | 25-004-1702                | 25-004-1412                   |
| 7B          | 3   | PLANET GEAR - PRIMARY                                  | 25-004-1712                     | 25-004-1652                    | 25-004-1722                | 25-004-1552                   |
| 7C          | 3   | PLANET SHAFT - PRIMARY                                 | 25-004-1442                     |                                |                            |                               |
| 7D          | 36  | ROLLER - 12 ROLLERS/PLANET                             | 01-106-0010                     |                                |                            |                               |
| 7E          | 6   | THRUST WASHER - PRI. PLANET                            | 13-004-1582                     |                                |                            |                               |
| 7F          | 3   | ROLL PIN (3/16 X 1)                                    | 01-153-0020                     |                                |                            |                               |
| 7G          | 12  | SPACER - PRI PLANET BEARING                            | 13-004-1592                     |                                |                            |                               |
| 12A         | 1   | RING GEAR - PRIMARY                                    | 25-004-1562                     |                                |                            |                               |
| 12B         | 1   | RING GEAR - SECONDARY                                  | 25-004-1612                     |                                |                            |                               |
| 14          | --- | THRUST WASHERS AND THRUST BRGS                         | -----                           |                                |                            |                               |
| 14A         | 1   | THRUST WASHER - INPUT GEAR                             | 25-004-1752                     |                                |                            |                               |
| 14B         | 2   | THRUST WASHER - CARRIER                                | 25-004-1132                     |                                |                            |                               |
| 16          | (1) | SEAL KIT (INCLUDES ITEMS 16A, 16B)                     | 25-016-2011                     |                                |                            |                               |
| 16A         | 1   | SHAFT SEAL   | NOT USED WITH CAT SEAL          | 01-405-0670                    |                            |                               |
| 16B         | 3   | SEAL (O-RING)  | 01-402-0020                     |                                |                            |                               |
| 16C         | 1   | RUBBER DIRT BOOT (OPTIONAL)                            | 01-406-0102                     |                                |                            |                               |
| 16D         | 1   | METAL FACE SEAL (CAT SEAL)                             | REQ'D FOR CAT SEAL              | 01-406-0103                    |                            |                               |
| 16E         | 1   | SEAL (O-RING) INTO CAT-SEAL ADAPTER                    | REQ'D FOR CAT SEAL              | 01-402-1020                    |                            |                               |
| 16F         | 1   | ADAPTER - CAT SEAL                                     | REQ'D FOR CAT SEAL              | 25-004-1858                    |                            |                               |
| 20          | --- | OUTPUT SHAFT BEARINGS                                  | -----                           |                                |                            |                               |
| 20A         | 1   | BEARING CONE - OUTER                                   | 01-102-0240                     |                                |                            |                               |
| 20B         | 1   | BEARING CUP - OUTER                                    | 01-103-0240                     |                                |                            |                               |
| 20C         | 1   | BEARING CONE - INNER                                   | 01-102-0250                     |                                |                            |                               |
| 20D         | 1   | BEARING CUP - INNER                                    | 01-103-0250                     |                                |                            |                               |
| 25          | --- | HARDWARE   | -----                           |                                |                            |                               |
| 25A         | 20  | HEX HEAD CAPSCREW (5/8-11 X 7) GR 8                    | 01-150-1630                     |                                |                            |                               |
| 25G         | 20  | LOCKWASHER - (5/8)                                     | 01-166-0040                     |                                |                            |                               |
| 30          | --- | PLUGS  | -----                           |                                |                            |                               |
| 30A         | 1   | PLUG - COVER   | 01-208-0030                     |                                |                            |                               |
| 30B         | 1   | PIPE PLUG (1/2 NPT MAGNETIC) - BASE                    | 01-207-0041                     |                                |                            |                               |
| 30C         | 1   | PLUG 1/4 NPT   | 01-207-0020                     |                                |                            |                               |
|             | 1   | GREASE FITTING (OPTIONAL)                              | 01-215-0040                     |                                |                            |                               |
| 35          | --- | MISCELLANEOUS  | -----                           |                                |                            |                               |
| 35A         | ★   | SHIM - SHAFT ADJUSTMENT                                | 25-004-1051                     |                                |                            |                               |
| 35B         | 1   | SPLIT RING- LOAD-N-LOCK                                | 25-004-1182                     |                                |                            |                               |
| 35C         | 1   | LOCK RING - LOAD-N-LOCK                                | 25-004-1192                     |                                |                            |                               |



\* QUANTITY OF SHIMS DETERMINED BY BEARING PRELOAD. X312LS2-Aa ECN: - DATE: 9-25-20 MTK